

Split Nails - PAINT TODAY 26/07

Work Order ID 70821-1
Wednesday, June 15, 2011 2:28:12 PM



ASAD

Page 1

Item ID: D3405-043

Accept



Setup Start



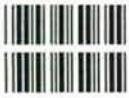
Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 6/15/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

P

Date: 11-06-15

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

0.00

11-6-15

FLOW CNC Waterjet

304.125

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

11-6-16

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

5uloxel,6

70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70821

Wednesday, June 15, 2011 2:28:12 PM



Page 2

Item ID: D3405-043

Accept



Setup

Start



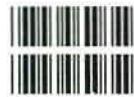
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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Brake NC

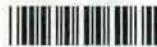
Memo

- 1-Deburr
- 2-Form using DT8204 as per Dwg D3405
- 3- use DT9681 to check if correct forming

SB 11/06/17

15

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 11/06/17

705

150



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: M117659 0.00

Large Fab

Memo

0.00

Weld as per Dwg D3405 use DT8484
Identify as D3405-043

R 11/7-25 X14

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Required Date: 6/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

H 11-07-26

(14)

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

M 11 07 26 (14)

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

MU7745.

Memo

0.00

START TIME:
OVEN TEMPERATURE:
FINISH TIME:9:15
400°
9:45.

14 BL 11-7-26.

W/O:		WORK ORDER CHANGES					
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Page 4

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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Quality Control

14. 6 11/17/2011

200

Identify as per dwg & Stock Location: 478

0.00



Packaging

Packaging

Memo

0.00

11/17/2011

210

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/17/2011

MM, 2011

W/O:		WORK ORDER CHANGES					
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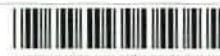
NOTE: Date & initial all entries

Picklist Print

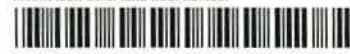
Wednesday, June 15, 2011 2:28:19 PM

Page 1

Work Order ID: 70821



Parent Item: D3405-043



Parent Item Name: Lug Assembly

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1 		Manufactured	No			100	Each	35.0000	1	10			11-7-25

GHW Lug

70664X14

Location Loc Qty Loc Code

WA	32	
69883	32	
WA030	3	
67127	3	

M304S11GA



304/316 0.125 Sheet

Purchased No

150	sf	127.0000	0.154	1.621053	2.5
-----	----	----------	-------	----------	-----

Location Loc Qty Loc Code

MAT020	127	
117494	127	

11-6-6
117494
15

T

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70821
Description: GHW Bracket	Part Number:	D3405-3
Inspection Dwg: D3405	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	JB
Date:	11-6-16

Audited by: C
Date: 11/06/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue P/O D3405-043	KJ/JLM	
B	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

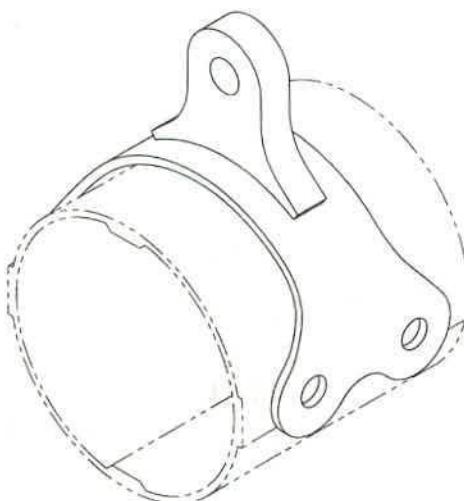
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

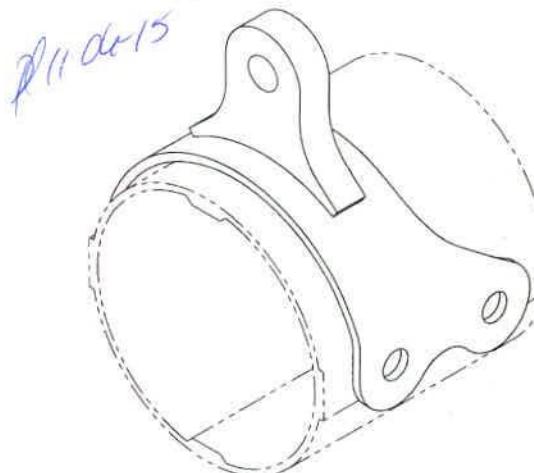
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76821



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18 M.P.

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.			AJS	08.09.19
A	NEW ISSUE			PH	05.03.08
	REV. DESCRIPTION			BY	DATE
DESIGN	PH	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. B		
MFG. APPR.		D3405	SHEET 1 OF 4		
APPROVED		TITLE	SCALE		
DE APPR.		GHW LUG ASSEMBLY	NTS		
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

8 7 6 5 4 3 2 1

NOTES:

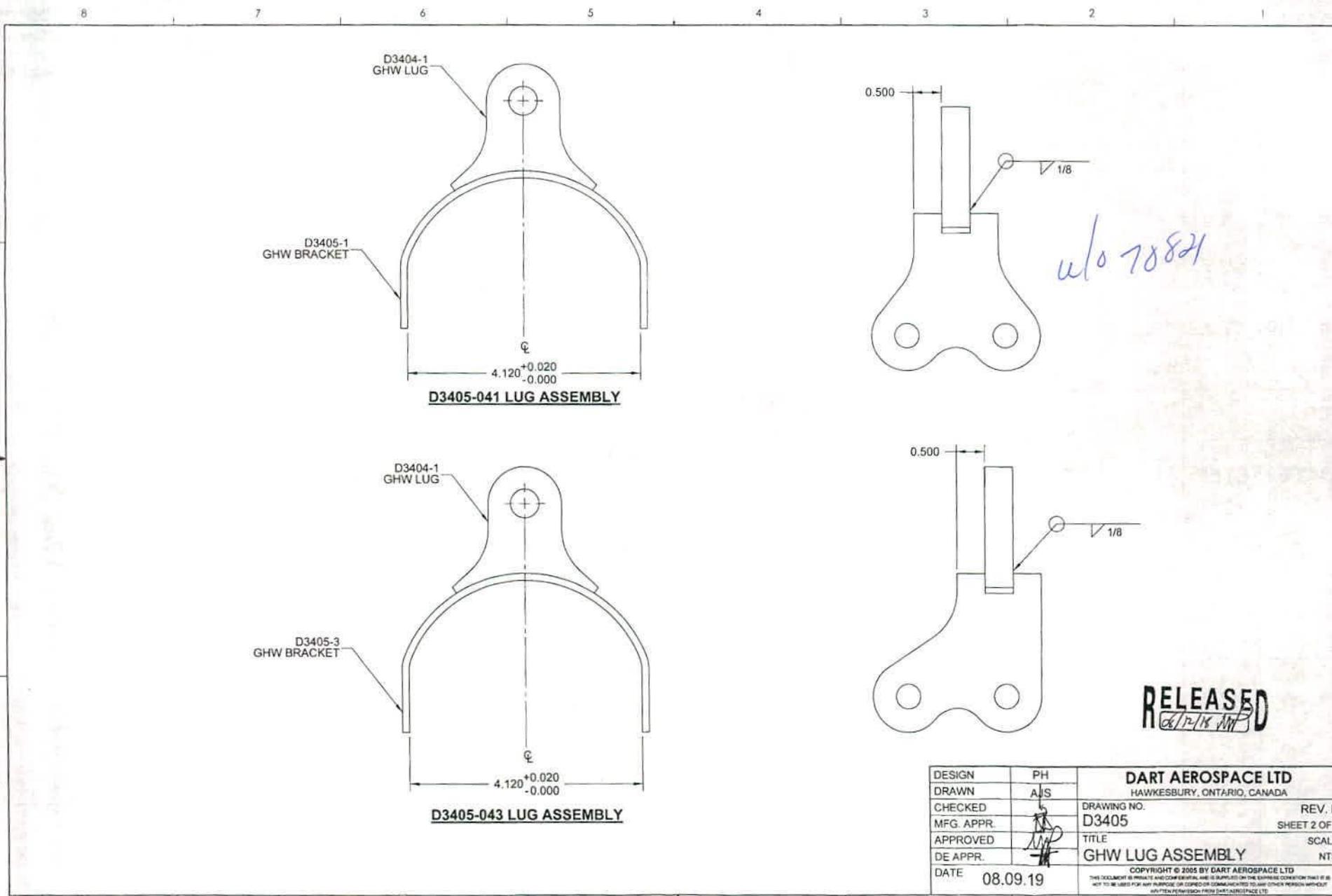
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

W/O:		WORK ORDER CHANGES					
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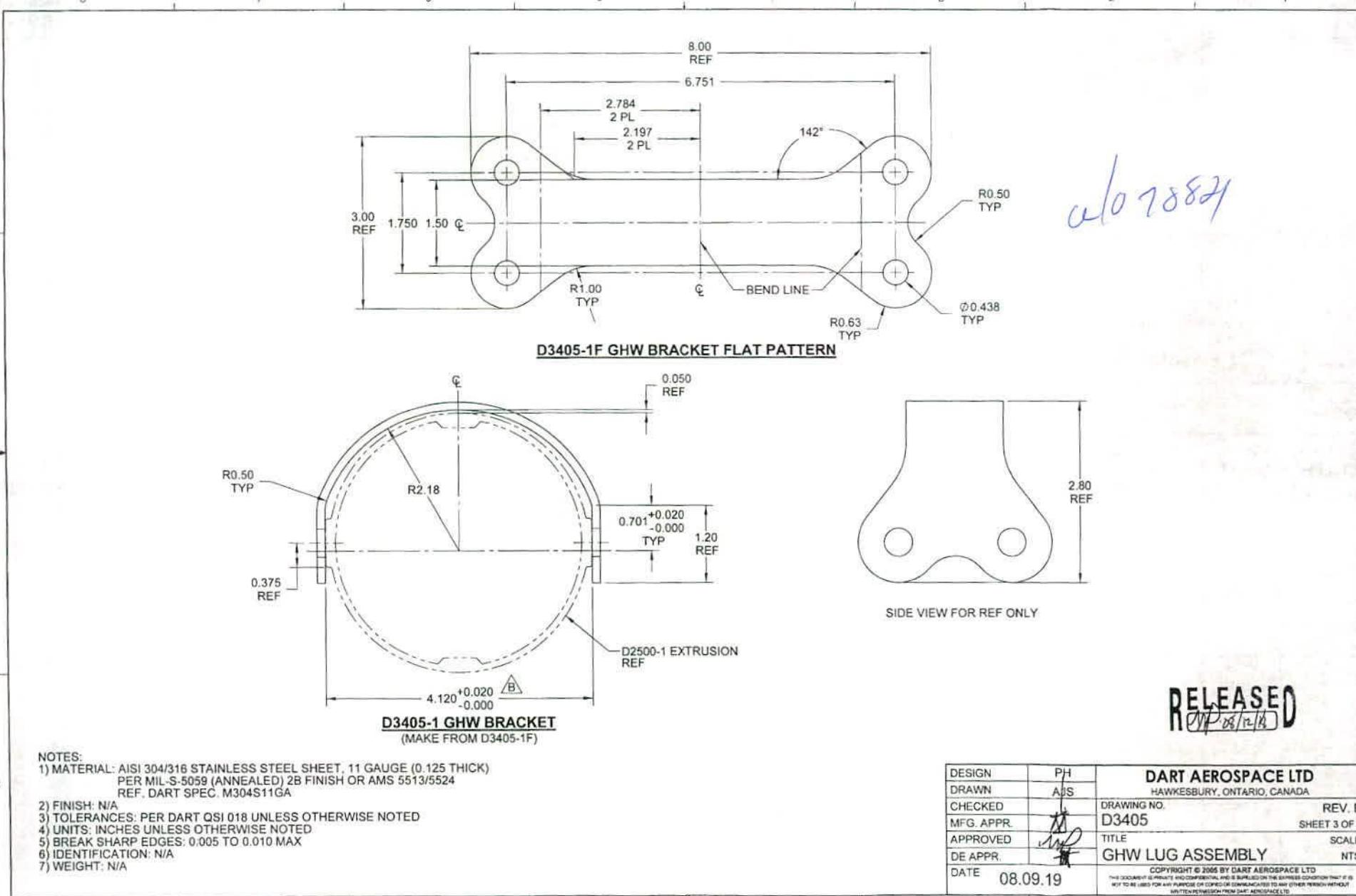
DESIGN	PH	DART AEROSPACE LTD
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3405
APPROVED		REV. B
DE APPR.		SHEET 2 OF 4
DATE	08.09.19	TITLE
		SCALE
		NTS
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DRAWN	ADS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D3405
DE APPR.		SHEET 3 OF 4
DATE	08.09.19	TITLE
		GHW LUG ASSEMBLY
		NTS

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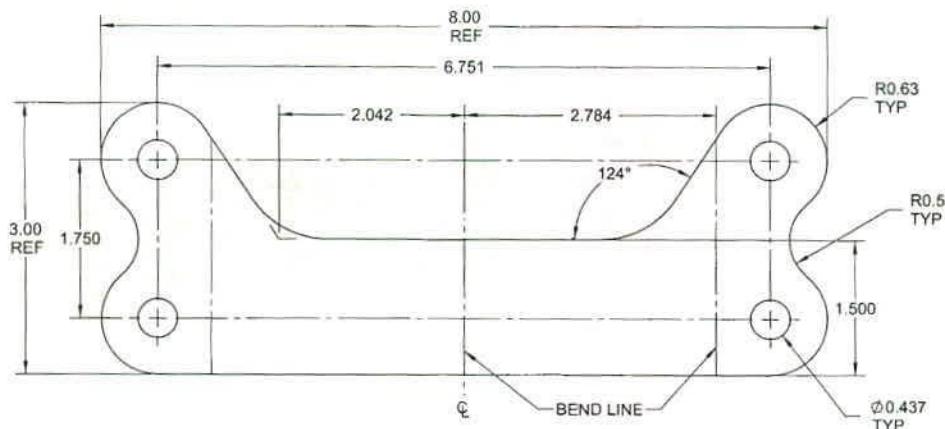
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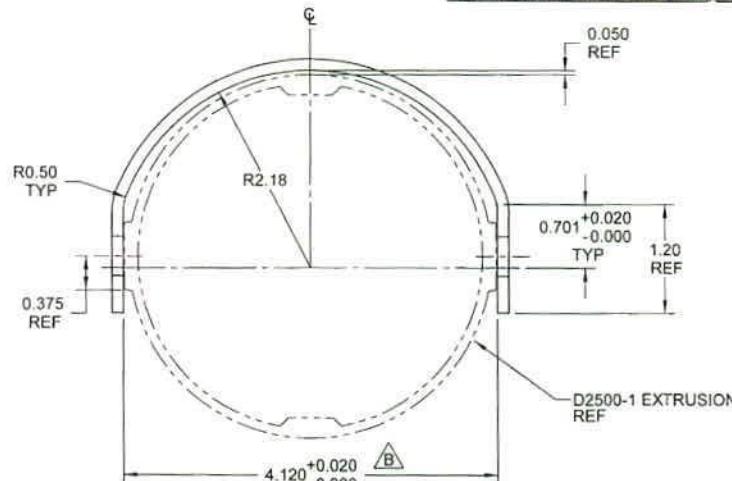
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8 7 6 5 4 3 2 1

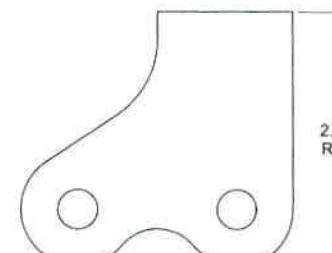


D3405-3F GHW BRACKET FLAT PATTERN

D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY

RELEASED
(08/12/18)

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
		D3405	SHEET 4 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		GHW LUG ASSEMBLY	NTS
DE APPR.			
DATE	08.09.19		

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